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No. 216

DEPARTMENT OF COMMERCE

BUREAU OF STANDARDS

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UNITED STATES GOVERNMENT MASTER SPECIFICATION FOR HELMET-SHAPED ICE BAGS

FEDERAL SPECIFICATIONS BOARD SPECIFICATION No. 216

This specification was officially promulgated by the Federal Specifications Board on November 5, 1924, for the use of the Departments and Independent Establishments of the Government in the purchase of helmet-shaped ice bags.

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I. TYPE

Helmet-shaped ice bags shall be of a single type as described below. Rubber ice bags are considered in Federal Specifications Board specification No. 217.

II. MATERIAL AND WORKMANSHIP

Bags shall be made of double-coated rubber sheeting with a smooth uniform soft finish, free from pits or other imperfections. An embossed surface will not be acceptable.

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III. GENERAL REQUIREMENTS

The bag shall be a combination ice bag and helmet and shall be suitably reinforced at seams and edges. The bag shall be of such design as to form a helmet which can be changed to a circular-shaped ice bag. When shaped as a helmet it shall be not less than 12½ inches in antero posterior measurement and not less than 11 inches in transverse measurement. In circular shape it shall be 12½ inches in diameter. The thickness of cloth inserted wall shall be 0.025 inch, with a tolerance of ±0.005 inch.

IV. DETAIL REQUIREMENTS

1. Fittings.—The stopper socket shall be of noncorrosive material and shall be threaded to give an accurate fit with the stopper. It shall be cemented and securely held in place near circumference of bag. The stopper shall be of noncorrosive material and shall be provided with a rubber washer which shall produce a water-tight seal and shall be covered with rubber fabric of the same material as ice bag. At one side of stopper socket and at a point opposite on the circumference of bag a rubberized fabric loop shall be firmly attached for suspension purposes. On either side of the bag and extending vertically to lower edge of helmet two loops of rubberized fabric shall be firmly attached to ice bag. These loops shall be at least 2½ inches long by one-half inch wide and shall allow clearance of 1 inch for passage of tying bands to secure helmet about head.

2. Fabric.—The sheeting shall be a plain weave, evenly woven, and free from imperfections and makeweight. It shall have a thread count of not less than 68 threads to the inch in the warp and 70 in the filling and shall weigh not less than 4.3 ounces per square yard. It shall have a tensile strength of not less than 60 pounds, warp and filling, determined by the strip method.

3. Finished Sheeting.—The tensile strength of the coated sheeting shall be not less than 65 pounds, warp and filling. Tests shall be made within 30 days from date of delivery, by the strip method on specimens 2 inches wide.

4. Rubber Content.—The rubber compound shall contain not less than 38 per cent by weight of best quality new wild or plantation rubber.

5. Inflation.—The ice bag when inflated with air at a pressure corresponding to 18 inches of water shall show no leakage, nor any indication of weakness.

V. SAMPLING

Manufacturers submitting samples of rubber compound, coated sheeting, or cloth insertion shall guarantee samples to be of the same

material and equivalent cure to that to be supplied in article to be furnished.

VI. PACKING AND MARKING

Each bag shall have the manufacturer's name or trade name vulcanized in raised letters. Bags shall be marked and packed as called for in the proposal.

VII. ADDITIONAL INFORMATION

No details specified.

VIII. GENERAL SPECIFICATIONS

General Specifications for Rubber Goods, F. S. B. Specification No. 59, and the general specification for textiles, in effect on date of issuance of proposals, shall form part of this specification.

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